Asap ship today 03/05

Work Order ID 82381 *82381*

March-30-12 7:45:12 AM

Item ID: D2012-113 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Clamp **Stop** *NS2*

Start Date: 29/03/2012 **Start Qty:** 16.00 *16*

Required Date: 12/04/2012 **Req'd Qty:** 16.00 *16*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12\03\30 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2012-113	**Revision Nbr** Rev C					(20)			
100 *100* Waterjet FLOW CNC Waterjet 304.063	FLOW WATER JET **Memo** 1-Cut as per Dwg D2012-113 Dwg Rev: C Prog Rev: C 2-Deburr if necessary	0.00 0.00							B12-5-1
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00							B12-5-1
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 S12105102				cuts (+20)			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82381

March-30-12 7:45:12 AM

82381

Item ID: D2012-113

Revision ID:

Item Name: Clamp

Start Date: 29/03/2012 **Start Qty:** 16.00 *16*

Required Date: 12/04/2012 **Req'd Qty:** 16.00 *16*

Reference:

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab	0.00							
	Memo 1- Deburr any rough edges 2- Bend as per Dwg D2012-113 using DT8458 3- Tumble	0.00				20			FF 12-05-02 FB 12-5-2
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00 S12/05/03				20			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 3	0.00							
	Memo	0.00				20.	12/5/3		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82381

March-30-12 7:45:12 AM

82381

Item ID: D2012-113

Revision ID:

Item Name: Clamp

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 29/03/2012 **Start Qty:** 16.00 *16*

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Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

MLJ 12/05/03

MF 12-05-03

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-30-12 7:45:16 AM

Work Order ID: 82381 *82381*

Parent Item: D2012-113 *D2012-113*

Parent Item Name: Clamp

Start Date: 29/03/2012 **Required Date:** 12/04/2012

Start Qty: 16.00 **Required Qty:** 16.00

Comments: IPP: F01.10.05Fixed Typo and Added Inspection Level 21SM
IPP Rev:G Now on Waterjet 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			110	sf	310.0160	0.015	0.252632	1.		

M304S16GA **

304/316 Sheet .063

B12-5-1

(20)

Location		Loc Qty	Loc Code
MAT020		310.016	
	120866	43.71	120866
	120877	143.306	
	121070	123	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	82381
Description: Clamp	Part Number:	D2012-113
Inspection Dwg: D2012-113 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.764	L		V BGZ	
0.40	+/-0.030	.403	L		V	
1.360	+/-0.010	1.360	L		V	
0.800	+/-0.010	.799	L		V	
Ø0.257	+0.006/-0.001	.256	L		V	
Ø0.191	+0.005/-0.001	.190	L		V	
2.96	+/-0.030	2.967	L		√	
0.063	+/-0.010	.060	L		V	

Measured by:	B
Date:	12-5-1

Audited by:	S
Date:	120512

Prototype Approval:	N/A
Date:	N/A

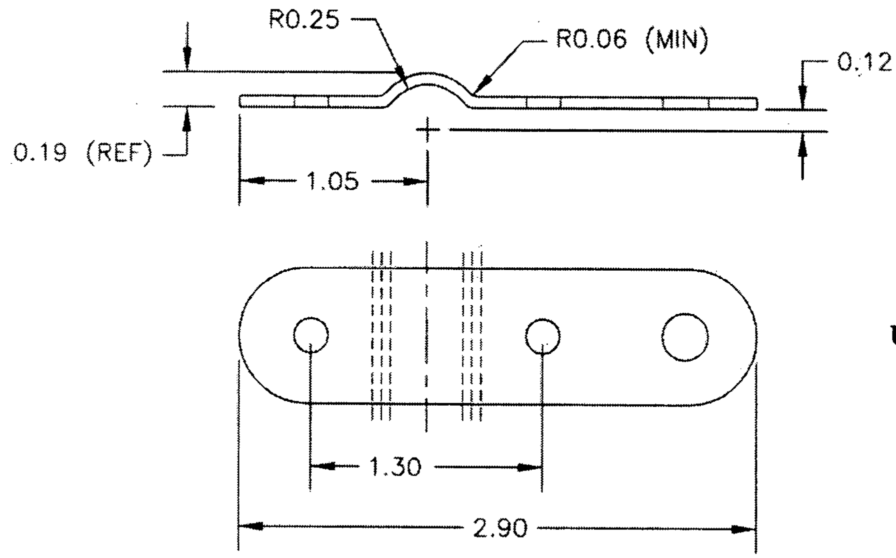
Rev	Date	Change	Revised by	Approved
A	07.05.08	New Issue	KJ/JLM [signature]	[signature]

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2012-113 — REV. C — SHEET 1 OF 1
DATE 00.04.28		TITLE CLAMP — SCALE 1:1

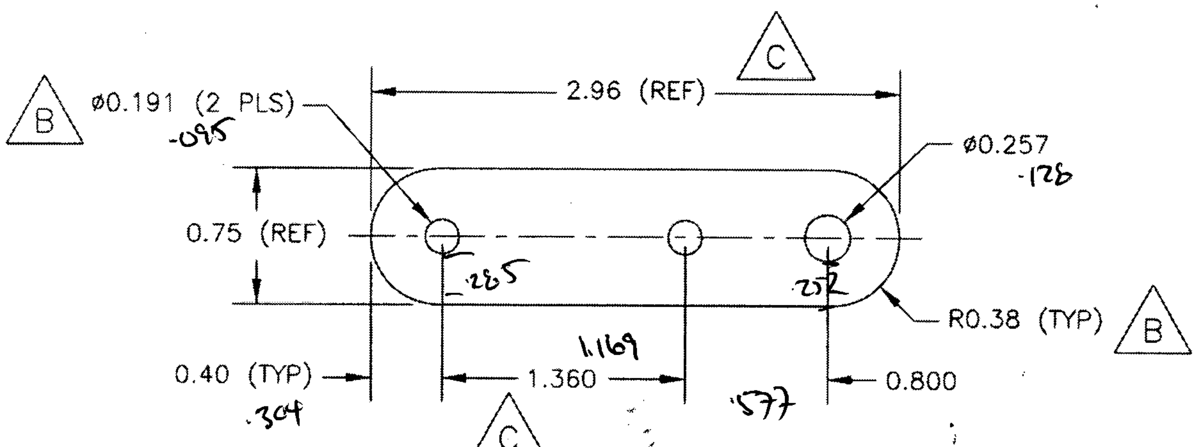
RELEASED 00.05.02

REV	DATE	DESCRIPTION
A	92.06.03	REDRAWN FROM D2012
B	00.02.23	REDRAWN; R0.38 WAS R0.50; ⌀0.191 WAS ⌀0.189; ADDED FLAT PATTERN
C	00.04.28	2.96 WAS 3.35; 1.360 WAS 1.745



BENT DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82381 MO
12/03/30



FLAT PATTERN

MATERIAL: AISI 304/316 SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES